

Work Order ID 65090



Thursday, January 06, 2011 10:40:33 AM

Page 1

Item ID: D2857-1

Accept



Setup Start

Revision ID:

Item Name: Hinge Bracket

Stop



Start Date: 1/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

11-01-6

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2857

Rev *B/C*

NA 11.01.00

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 4.425"

conf 11/03/07

20

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA940
FOLIO REV: *AA*
DWG REV: *C*
2-Deburr any rough edges

conf 11/03/09

20

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

conf 11/03/09

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name:	Hinge Bracket				Stop	
Start Date:	1/6/2011	Start Qty:	20.00			
Required Date:	1/13/2011	Req'd Qty:	20.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							20 BL 11-3-9
160 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo START TIME: 3:35 OVEN TEMPERATURE: 320° FINISH TIME: 4:05	0.00							20 BL 11-3-14

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Page 3

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Setup Start



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Item Name: Hinge Bracket

Stop



Start Date: 1/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				20	4	21	11/03/15
Quality Control									
180	Identify as per dwg & Stock Location: 24	0.00							
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/3/15 200

11/3/15

MF 11-03-15

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, January 06, 2011 10:40:37 AM

Page 1

Work Order ID: 65090

Parent Item: D2857-1

Parent Item Name: Hinge Bracket



Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C 00.06.22 Removed P/O for powder coat EC
 IPP D 06.05.01 Added level 8 EC IPP Rev:E
 10.06.10 remove seq150 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	10.3055	0.37	7.789474			



6061-T6 Bar 2.00 x 1.25



Location	Loc Qty	Loc Code
MAT	10.3055	
114507	7.6555	
114899	2.65	

M116623

X 7.789'

On 1/03/07

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	65090
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300	—		Vern	MLZ
4.000	+/-0.010	4.004	—		"	"
0.340	+/-0.010	.341	—		"	"
1.110	+/-0.005	1.110	—		"	"
1.790	+/-0.010	1.793	—		"	"
1.320	+/-0.005	1.321	—		"	"
2.000	+/-0.010	2.003	—		"	"
0.340	+/-0.010	.341	—		"	"
0.447	+/-0.010	.457	—		"	"
Ø0.171	+0.005/-0.000	Ø.173	—		"	"
0.147	+/-0.010	.149	—		"	"
0.376	+/-0.010	.378	—		"	"
0.126	+/-0.010	.126	—		"	"
0.063	+/-0.010	.065	—		"	"
Ø0.166	+0.005/-0.000	Ø.168	—		"	"
0.911	+/-0.010	.910	—		"	"
0.600	+/-0.010	.600	—		"	"
0.125	+/-0.010	.123	—		"	"
0.150	+/-0.010	.149	—		"	"

Measured by:	MLZ
Date:	11/03/09

Audited by:	SL
Date:	11/03/09

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

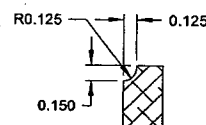
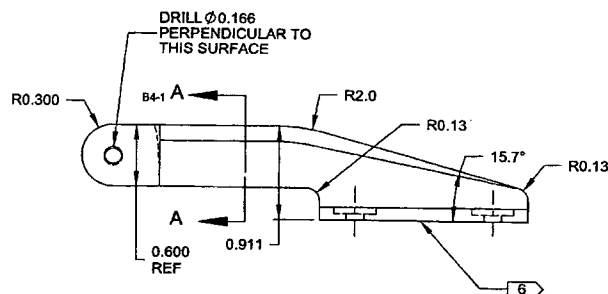
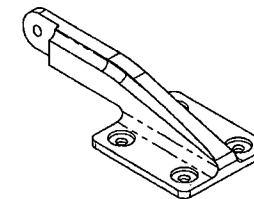
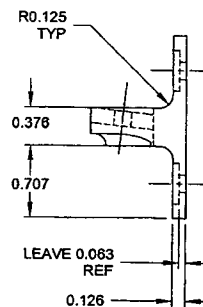
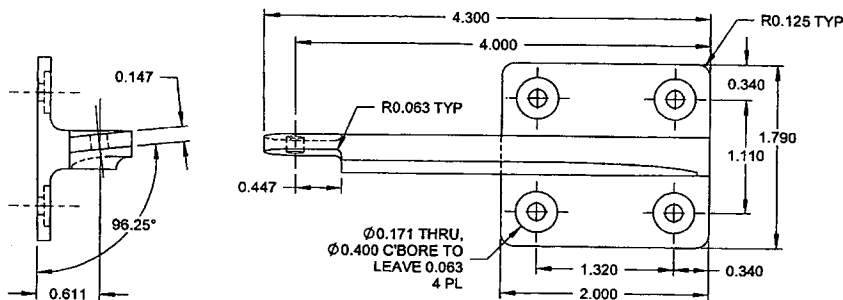
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NOTE: Date & initial all entries



B7-1 SECTION A-A

D2857-1 HINGE BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15090
11-01-C

RELEASED
2010-11-26

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1(FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG, IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	06.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.13		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2857 HINGE BRACKET <small>COPYRIGHT © 1988 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			
		REV. C	SHEET 1 OF 2
		SCALE	NTS

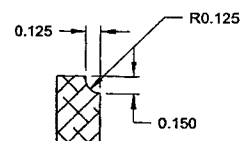
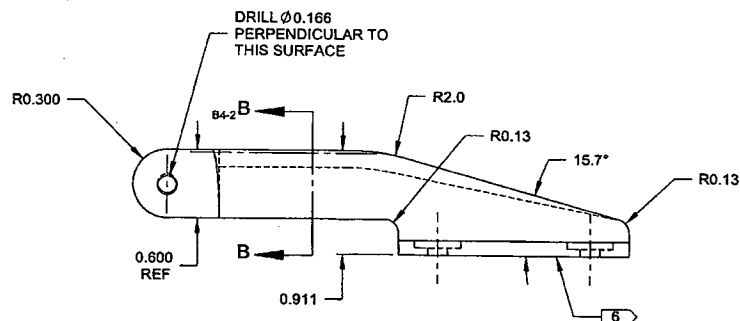
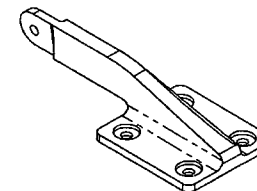
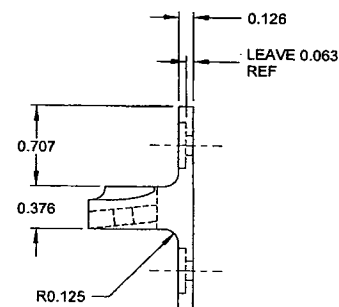
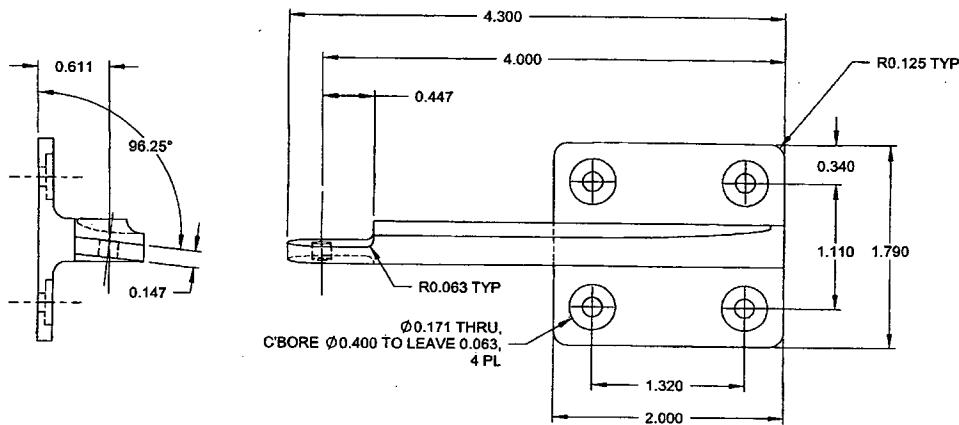
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NOTE: Date & initial all entries



B7-2 SECTION B-B

D2857-2 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M8081T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-2" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	91	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2857	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE BRACKET	NTS
DATE	10.09.13	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-11-26

W6 65090

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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